

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018577**Date Inspected:** 01-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shi Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Trial Assembly Yard

This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG segment 12AE, buttering weld No.LD3003A at Crossbeam side. The welder is identified as #047353. ZPMC QC is identified as Mr. An Qing Xiang . The welding variables recorded by QC appear to comply with WPS-345-FCAW-2G(2F)-ESAB-REPAIR. Weld repair report is identified as WR17894.

FCAW in the 2G position for the OBG segment 12AE, buttering weld No.LD3004A at bike path side. The welder is identified as #047353. ZPMC QC is identified as Mr. An Qing Xiang . The welding variables recorded by QC appear to comply with WPS-345-FCAW-2G(2F)-ESAB-REPAIR. Weld repair report is identified as WR17894.

SMAW in the 2F position for the OBG segment 11EW, repair weld No.SP508-001-001/002 at Cross beam side. The welder is identified as #053486. ZPMC QC is identified as Mr. Shi Lei . The welding variables recorded by QC appear to comply with WPS-345-SMAW-2G(2F)- REPAIR-FCM-1. Weld repair report is identified as

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WR16610.

SMAW in the 2F position for the OBG segment 11DW, repair weld No.SP507-001-057/058 at Cross beam side. The welder is identified as #053486. ZPMC QC is identified as Mr. Shi Lei . The welding variables recorded by QC appear to comply with WPS-345-SMAW-2G(2F)- REPAIR -FCM-1. Weld repair report is identified as WR16610.

SMAW in the 4G position for the OBG segment 11EE, repair weld No.SEG074A-014 at bike path side. The welder is identified as #053871. ZPMC QC is identified as Mr. An Qing Xing . The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-REPAIR-FCM-1. Weld repair report is identified as CWR2312-R1.

Ultrasonic Testing (A,B,C and D-Scan)

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as splice joint joining between bottom Plate to bottom Plate for OBG segment 11DE to 11EE . The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

OBE11C-008

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as butt joint joining between bottom Plate to side Plate for OBG segment 11DW at cross beam side. The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

SEG071-045

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as butt joint joining between bottom Plate to side Plate for OBG segment 11EW at cross beam side. The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

SEG073-014

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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Dsouza,Christopher	QA Reviewer
